

May 10, 2010



U.S. Department
of Transportation

East Building, PHH-30
1200 New Jersey Avenue S.E.
Washington, D.C. 20590

**Pipeline and Hazardous
Materials Safety Administration**

DOT-SP 14950

EXPIRATION DATE: April 30, 2012

(FOR RENEWAL, SEE 49 CFR § 107.109)

1. GRANTEE: Certified Cylinder, Division of American
Welding & Tank, LLC
Crossville, TN
2. PURPOSE AND LIMITATION:
 - a. This special permit authorizes the rebuilding or modification and sale of certain DOT Specification 4B, 4BA, and 4BW cylinders for use in the transportation in commerce of certain hazardous materials. This special permit provides no relief from the Hazardous Materials Regulations (HMR) other than as specifically stated herein. The most recent revision supersedes all previous revisions.
 - b. The safety analyses performed in the development of this special permit only considered the hazards and risks associated with the transportation in commerce.
 - c. No party status will be granted to this special permit.
3. REGULATORY SYSTEM AFFECTED: 49 CFR Parts 106, 107 and 171-180.
4. REGULATIONS FROM WHICH EXEMPTED: 49 CFR of §§ 172.203(a) and 172.301(c) in that the marking requirements are waived and § 180.211 in that a modification is being performed to the upper head.
5. BASIS: This special permit is based on the application of Certified Cylinder, Division of American Welding & Tank, LLC dated July 29, 2009 submitted in accordance with § 107.105 and additional information dated December 15, 2009 and April 14, 2010 and the public proceeding thereon.

6. HAZARDOUS MATERIALS (49 CFR § 172.101):

Hazardous Materials Description			
Proper Shipping Name	Hazard Class/ Division	Identification Number	Packing Group
Hazardous materials authorized for transportation in DOT 4B, 4BA, and 4BW cylinders per 49 CFR Part 173	As appropriate	As appropriate	As appropriate

7. SAFETY CONTROL MEASURES: This special permit authorizes the rebuilding or modification (replacement or addition of openings for outlet fittings on the upper head) of DOT Specification 4B, 4BA and 4BW steel cylinders in accordance with the following:

a. Only cylinders originally manufactured to a DOT Specification 4B, 4BA or 4BW may be rebuilt or modified and represented as DOT 4B, 4BA or 4BW cylinders. Changes from one DOT specification to another are prohibited.

b. Rebuilding must be performed in accordance with § 180.211. Modification work must be performed in accordance with Certified Cylinder Workstation Procedure and Inspection Details, drawings, and welding procedures on file with the Office of Hazardous Materials Special Permits and Approvals (OHMSPA), and in accordance with § 180.211 except for the heat treatment requirements of § 180.211(d)(2)(i).

c. Certified Cylinder must be considered a manufacturer subject to the requirements of § 178.2(a)(2) and Subpart C of Part 178.

d. After removal of a non-pressure component and before replacement of any non-pressure component, the cylinder must be visually inspected in accordance with the requirements of CGA Pamphlet C-6. Rejected cylinders must be repaired and rebuilt as prescribed in § 180.211 or condemned.

e. Rebuilding or modification of any cylinder involving a joint subject to internal pressure may only be performed by fusion welding. The rebuilder may rebuild a DOT 4B, 4BA or

May 10, 2010

4BW cylinder having a water capacity of 20 pounds or greater by replacing a head of the cylinder using a circumferential joint. When this weld joint is located at other than an original welded joint, a notation of this modification must be shown on the Manufacturer's Report of Rebuilding (see Appendix A). Weld joint must be on the cylindrical section of the cylinder.

f. Welding must be:

- (1) Performed in accordance with the procedures and qualification requirements of CGA Pamphlet C-3.
- (2) Performed using welding rods compatible with the material of the cylinder including any non-pressure component.
- (3) Performed on an area free of any contaminant.
- (4) For modifications only, performed in accordance with the procedures and qualification requirements of CGA Pamphlet C-3 and with National Board Inspection Code Part 3 paragraphs 2.5.3 and 2.5.3.1 on file with OHMSPA.
- (5) Welding operators must be qualified to Certified Cylinder Welding Procedure Specification C-3-1 on file with the OHMSPA.

g. Each rebuilt or modified cylinder must be:

- (1) Heat treated as required in the applicable specification. Cylinders to be modified only are not required to be heat treated.
- (2) Subjected to a full hydrostatic volumetric expansion test as specified in the applicable cylinder specification in Part 178. The results of the tests must conform to the requirements of the applicable cylinder specification.
- (3) Inspected and have test data reviewed to determine conformance with the applicable cylinder specification.
- (4) Made of material in conformance with the specification. Determination of conformance must include chemical analysis, verification, inspection and tensile testing of the replaced part. Tensile tests

May 10, 2010

must be performed by lots defined in the applicable specification.

h. A record of rebuilding, in the format presented in Appendix A, must be completed for each rebuilt or modified cylinder.

i. A copy of the reports of rebuilding or modification must be maintained by the rebuilding facility for at least 15 years.

8. SPECIAL PROVISIONS:

a. The marking requirements of §§ 172.203(a) and 172.301(c) are waived.

b. Each packaging rebuilt or modified under the authority of this special permit must be either (1) marked with the name of the rebuilder and location (city and state) of the facility at which it is rebuilt or modified or (2) marked with a registration symbol designated by the Office of Hazardous Materials Special Permits and Approvals for a specific rebuilding facility.

c. Each packaging rebuilt or modified under the authority of this special permit and in accordance with an approval issued under § 180.211 must be marked with the approval number issued to the holder of this special permit.

d. The most recent revision of this special permit must be maintained at the facility where the packaging is rebuilt or modified and must be made available to the DOT representative upon request.

e. In accordance with the provisions of paragraph (b) of § 173.22a, persons may use the packaging authorized by this special permit for the transportation of the hazardous materials specified in paragraph 6, only in conformance with the terms of this special permit.

f. A person who is not a holder of this special permit, but receives a packaging covered by this special permit, may reoffer it for transportation provided no modifications or changes are made to the packaging and it is offered for transportation in conformance with this special permit and the HMR.

May 10, 2010

9. MODES OF TRANSPORTATION AUTHORIZED: Motor vehicle, rail freight, cargo vessel, cargo aircraft only and passenger-carrying aircraft (unless forbidden by the HMR).
10. MODAL REQUIREMENTS: A current copy of this special permit must be carried aboard each cargo vessel, aircraft, or motor vehicle used to transport packages covered by this special permit. The shipper must furnish a copy of this special permit to the air carrier before or at the time the shipment is tendered.
11. COMPLIANCE: Failure by a person to comply with any of the following may result in suspension or revocation of this special permit and penalties prescribed by the Federal hazardous materials transportation law, 49 U.S.C. 5101 et seq:
 - o All terms and conditions prescribed in this special permit and the Hazardous Materials Regulations, 49 CFR Parts 171-180.
 - o Persons operating under the terms of this special permit must comply with the security plan requirement in Subpart I of Part 172 of the HMR, when applicable.
 - o Registration required by § 107.601 et seq., when applicable.

Each "Hazmat employee", as defined in § 171.8, who performs a function subject to this special permit must receive training on the requirements and conditions of this special permit in addition to the training required by §§ 172.700 through 172.704.

No person may use or apply this special permit, including display of its number, when this special permit has expired or is otherwise no longer in effect.

Under Title VII of the Safe, Accountable, Flexible, Efficient Transportation Equity Act: A Legacy for Users (SAFETEA-LU)—"The Hazardous Materials Safety and Security Reauthorization Act of 2005" (Pub. L. 109-59), 119 Stat. 1144 (August 10, 2005), amended the Federal hazardous materials transportation law by changing the term "exemption" to "special permit" and authorizes a special permit to be granted up to two years for new special permits and up to four years for renewals.

12. REPORTING REQUIREMENTS: Shipments or operations conducted under this special permit are subject to the Hazardous Materials Incident Reporting requirements specified in 49 CFR §§ 171.15 - Immediate notice of certain hazardous materials incidents, and 171.16 - Detailed hazardous materials incident reports. In addition, the grantee(s) of this special permit must notify the Associate Administrator for Hazardous Materials Safety, in writing, of any incident involving a package, shipment or operation conducted under terms of this special permit.

Issued in Washington, D.C.:



for Dr. Magdy El-Sibaie
Associate Administrator for Hazardous Materials Safety

Address all inquiries to: Associate Administrator for Hazardous Materials Safety, Pipeline and Hazardous Material Safety Administration, U.S. Department of Transportation, East Building PHH-30, 1200 New Jersey Avenue, Southeast, Washington, D.C. 20590.

Copies of this special permit may be obtained by accessing the Hazardous Materials Safety Homepage at http://hazmat.dot.gov/sp_app/special_permits/spec_perm_index.htm. Photo reproductions and legible reductions of this special permit are permitted. Any alteration of this special permit is prohibited.

PO: CWF

May 10, 2010

APPENDIX A
Manufacturer's Report of Rebuilding

Cylinder Identification

Manufacturer _____

Cylinder Specification Number and Service Pressure _____

Cylinder Serial Number _____

Date of Original Manufacture _____

Other Identification Marks _____

Rebuild Information

Chemical Analysis of Replacement Parts

Parts Being Replaced _____

Heat Identification _____

Steel Manufactured by _____

Analysis Performed by _____

C	P	S	SI	Mn	Ni	Cr	Mo	Cu	AL	Zr
_____	_____	_____	_____	_____	_____	_____	_____	_____	_____	_____

Record of Physical Test Replacement Parts

Yield	Tensile	Elongation in	Reduction of	Weld	Weld
PSI	PSI	_____inches	Area %	Tensile	bend
_____	_____	_____	_____	_____	_____

Record of Hydrostatic Test

Calculated Volumetric Capacity of Cylinder Being Rebuilt

Actual Test	Total	Permanent	% of Total	Volumetric
Pressure	Expansion	Expansion	to Perman.	Capacity
_____	_____	_____	_____	_____

(Volumetric capacity of rebuilt cylinder must be + or 3% of the calculated capacity)

I certify that this rebuilt cylinder is accurately represented by the data above and that all provisions of DOT-SP 14950 and other applicable regulations have been complied with.

Repair Technician _____ Date _____

Company Representative _____ Date _____